

Work Order ID 63516

November 3, 2010 11:07:27 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4108-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting, Litter Door

Start Date: 04/11/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2010 Req'd Qty: 1.00

Customer:



Reference:

10.11.03

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4108

A

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

gmk 10/11/04

1 0

Jeaspa Bandsaw

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA964

FOLIO REV: *44*

DWG REV: *A*

gmk 10/11/04

1 0

DEBURR

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Item ID: D4108-9

Accept



Setup Start



Revision ID:

Item Name: Fitting, Litter Door

Stop



Start Date: 04/11/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00				1	0		
Quality Control									
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00				1	0		
Quality Control									
140	Identify as per dwg & Stock Location: <i>9246</i>	0.00							
Packaging	Memo	0.00							
Packaging									

change to RD1348 Nov

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Item ID: D4108-9

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Start Date: 04/11/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u 10-11-05

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

u
10/11/05

Picklist Print

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Page 1

Work Order ID: 63516



Parent Item: D4108-9



Parent Item Name: Fitting, Litter Door

Start Date: 04/11/2010

Required Date: 09/11/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-10-12 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B2.000X03.000		Purchased	No			100	f	7.3400	0.3125	0.328947			
304 BAR 2.000" X 3.000"													

Location	Loc Qty	Loc Code
MAT	7.34	
115894	7.34	

M6061 T6B2.00X 3.500
(FACE AS PER FOLIO)

Full
10.11.03

M112764

1.3289 and 10/11/03

DART AEROSPACE LTD		Work Order: 63576
Description: FITTING LITTER DOOR		Part Number: D 4108-9
Inspection Dwg: D4108 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

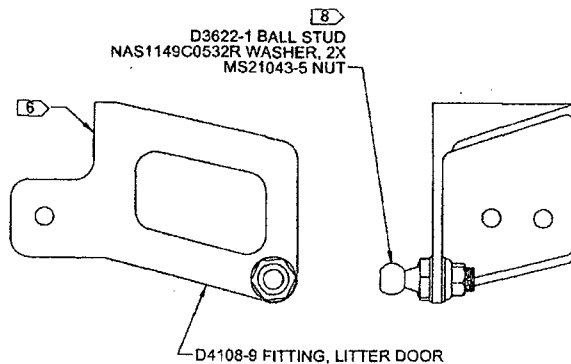
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.78	± 0.030	1.779	—		Vern	ML-7
.100	± 0.010	.100	—		"	"
3.63	± 0.030	3.632	—		"	"
.125	± 0.010	.124	—		"	"
R.25	± 0.030	R.250	—		Rad-gage	REF
.125	± 0.010	.128	—		Vern	ML-7
R.13	± 0.030	R.125	—		Rad-gage	REF
1.48	± 0.030	1.477	—		Vern	ML-7
Ø.234	± 0.005	Ø.234	—		"	"
.37	± 0.030	.363	—		"	"
.66	± 0.030	.657	—		"	"
R.13	± 0.030	R.125	—		Rad-gage	REF
2.00	± 0.030	1.997	—		Vern	ML-7
1.00	± 0.030	.998	—		"	"
.53	± 0.030	.527	—		"	"
.44	± 0.030	.435	—		"	"
R.25	± 0.030	R.250	—		Rad-gage	REF
1.06	± 0.030	1.060	—		Vern	ML-7
2.57	± 0.030	2.563	—		"	"
2.27	± 0.030	2.266	—		"	"
Ø.316	± 0.006	Ø.319	—		"	"
2.06	± 0.030	2.052	—		"	"
.40	± 0.030	.400	—		"	"
.100	± 0.010	.100	—		"	"

Measured by: <i>amk</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 10/11/04	Date: 10.11.04	Date:

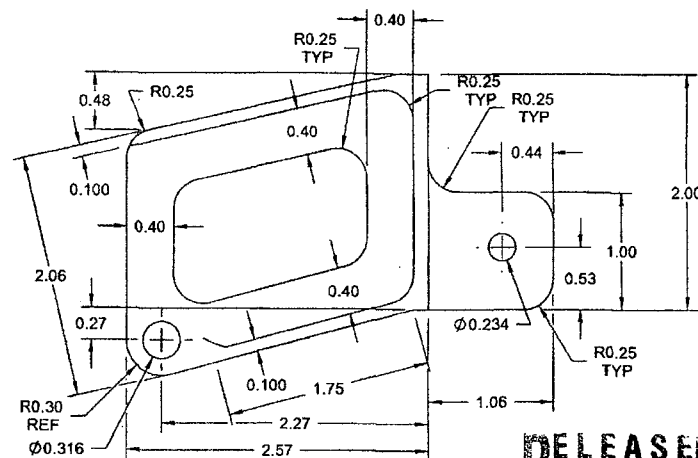
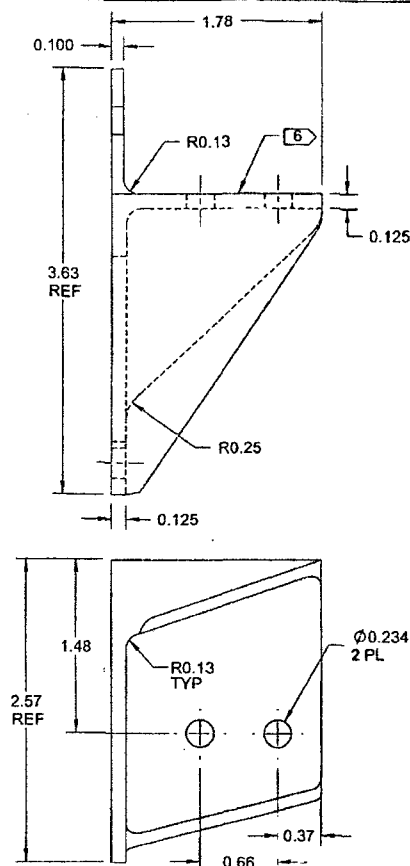
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

[Signature] 10.04.15

Qty	Part Number	Description
-049	D4108-049	LITTER DOOR FITTING ASSEMBLY
1	D4108-9	FITTING, LITTER DOOR
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER



D4108-049 LITTER DOOR FITTING ASSEMBLY



D4108-9 FITTING, LITTER DOOR

NOTES:

- 1) MATERIAL -9: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303B OR M304B
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4108-X & B/N PER QSI 044 6.1
- 7) WEIGHT -049: 0.44 lbs
- 8) TORQUE TO 15 INCH POUND.

6061-T6 ALUMINUM
MD 10/11/13

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4108	SHEET 6 OF 7
APPROVED		TITLE	SCALE
DE APPR.		DOUBLERS & FITTINGS	NTS
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD	

RELEASED
2010-09-23